



Dart Aerospace Ltd.
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K10111

Job Sheet 186066



Part No: K10111

Job Qty: 1 ea

Part Name: Saddle, Skidtube 206



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/9/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSI 9583 REV A, K10111 REV C IPP : F 01.11.08 Revised Step 5 and Added Inspection Level 21 SM
IPP REV:G 11.09.23 PER REV.B DD VERF:EC IPP REV:H 11.11.14 AS PER DSI9583 DD VERF:EC

Ship Via:

6476

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/23/18	0.00	0.00	Start Up Stores/Pkg-2	8:00	NOV 14 2018
110	Packaging	1 pcs		11/23/18	0.00	0.00	Packaging1-5	8:00	NOV 22 2018
120	QC	1 pcs		11/23/18	0.00	0.00	QC4		NOV 26 2018
125	DC	1 pcs		11/23/18	0.00	0.00	DC		NOV 26 2018
130	Packaging	1 pcs		11/23/18	0.00	0.00	Packaging3-2		NOV 26 2018
140	QC21-SA	1 Ea		11/23/18	0.00	0.00	QC21		NOV 26 2018

Part Op 125 - Photocopy bluefile & type labels per PPP K10111 CHG003 FOR D206-642-111 CHG009 FOR D206-642-113
Descriptions: CHG005

130 - Identify and pack for shipping as per PPP K10111 PPP D206-642-111 PPP D206-642-113 Location: _____

PPP rev: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-41A	Bolt	8 Ea (8 ea)	90-Start up Operation	38750
AN4-6A	Bolt	12 Ea (12 ea)	90-Start up Operation	5053945
AN4C5A	Bolt	1 Ea (1 ea)	90-Start up Operation	5019407
AN5-10A	Bolt	4 Ea (4 ea)	90-Start up Operation	5054109
AN5-11A	Bolt	4 Ea (4 ea)	90-Start up Operation	5003927
AN6-44A	Bolt	2 Ea (2 ea)	90-Start up Operation	5123265
D206-651-041	206 A/B Ground Handling Wheel	1 Ea (1 ea)	90-Start up Operation	5127463
D2652	Bushing	16 Ea (16 ea)	90-Start up Operation	5122721 x6
D2661-1	Saddle, LH, Fwd, Aft, Out	2 Ea (2 ea)	90-Start up Operation	5160726
D2662-1	Saddle, LH Fwd, Aft, In	2 Ea (2 ea)	90-Start up Operation	5161621 x1
D2712	Set Screw	10 Ea (10 ea)	90-Start up Operation	5128725
D2884	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	5059551
D2885	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	5022936
D3413-1	O-Ring	1 Ea (1 ea)	90-Start up Operation	5054580
MS21042L3	Nut	8 Ea (8 ea)	90-Start up Operation	5165886
MS21042L4	Nut	12 Ea (12 ea)	90-Start up Operation	5094592
MS21042L6	Nut	2 Ea (2 ea)	90-Start up Operation	5109736
NAS1149C0463R	Washer	1 Ea (1 ea)	90-Start up Operation	5104002
NAS1149D0363J	Washer	8 Ea (8 ea)	90-Start up Operation	5104373
NAS1149D0463J	Washer	24 Ea (24 ea)	90-Start up Operation	5095293
				3092780

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Step #: _____

QTY Effective : _____

MRB (QSI042) Approval

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Date: 11/14/18

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www.dartaero.com



Container No: S127889



Part: K10111

Job No: 186066

Serial No/Batch: S127889

Revision:

Inspector:

Exp Date:

Instructions:

				FAULT CATEGORY							
Design	☐	Operator	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Doc/Data	☐	Offset/Setup	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Equip/Tooling	☐	Supplier	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Handling/Pre	☐	Training	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Material	☐	Use for Testing	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Internal Transport	☐	Poor Information	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Tribal Knowledge	☐	Rushing	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
LOA	☐	Product Improvement	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
Substation	☐	Process Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Past Expiry Date	☐	Manufacturing Process	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Misidentified	☐	Past Due	☐	OTHER :							

NAS1149D0563J	Washer	8 Ea (8 ea)	90-Start up Operation
NAS1149D0663J	Washer	4 Ea (4 ea)	90-Start up Operation

050033
5093765

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-41A	8	122	0
	AN4-6A	12	726	0
	AN4C5A	1	62	0
	AN5-10A	4	253	0
	AN5-11A	4	88	0
	AN6-44A	2	130	0
	D206-651-041	1	2	0
	D2652	16	253	0
	D2661-1	2	4	0
	D2662-1	2	3	0
	D2712	10	537	0
	D2884	2	54	0
	D2885	2	38	0
	D3413-1	1	54	0
	MS21042L3	8	2,035	0
	MS21042L4	12	2,459	0
	MS21042L6	2	280	0
	NAS1149C0463R	1	487	0
	NAS1149D0363J	8	2,153	0
	NAS1149D0463J	24	3,231	0
	NAS1149D0563J	8	1,404	0
	NAS1149D0663J	4	866	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Change Record

Part Number K10111Page 1 of 1

Description SADDLE KIT FOR D206-642-111/-113

[illegible]

